

Date: Monday, 2/5/2007 8:07:31 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BAR
Job Number	: 30603		
Estimate Number	: 10390		
P.O. Number	: <i>N/A</i>	Part Number	: D3197041
This Issue	: 2/5/2007	Drawing Number	: D3197 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i>	Drawing Revision	: B
Previous Run	: 26082	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 2/9/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	10 Um: Each
Comment	: Est Rev: A New Issue 05-11-08 JLM Est Rev: B As per Rev B 06-03-10 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M7075T73R1000	7075-T73 Round Bar 1" OD
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Comment: Qty.: 2.5410 f(s)/Unit Total: 25.4100 f(s)
 Material: 7075-T73 (QQ-A-200/11) or (QQ-A-225/9) 1" OD
 (M7075T73R1.000)
 Identify for D3197-1
 Batch: *M100286*

mk 07/02/23 16

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: 29.125" long

mk 07/02/23 10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 1-Face ends to length per dwg D3197

 2-Machine D3197-1 as per Folio FA340 and Dwg D3197

 3-Deburr

J.F. 07/02/25 (10)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/02/25 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LATHE CONV.

CONVENTIONAL LATHE



Comment: CONVENTIONAL LATHE
Chamfer as per Dwg D3197

J.F. 07/02/27 (10)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/02/27 (10)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

R.m 07/02/28 (10)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m/01601

F.L. M.R. 07/03/01 (10)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

D26905

Lanyard ass'y



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2690-5 Lanyard B30663

SAD 07/03/02 (10)

11.0

D32421

Tag



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3242-1 TAG B26415

SAD 07/03/02 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

AN960JD10

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

6 AN960JD10

Washer M100279

SAN 07/02/02 (10)

13.0

D34893200

PIP PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3489-3-200

Pip Pin 34 100259 (3) B26707 (17)

SAB 07/03/02 (10)

14.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 MS21042L3

Nut (or -3) M103585

SAD 07/03/02 (10)

15.0

MS27039124

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 MS27039-1-24 Screw M100279

SAD 07/03/02 (10)

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble D3197-041 as per Dwg D3197

SAD 07/03/02 (10)

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

02/03/05 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Machine Or Operation:

Description :

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

EP 7/03/15 (10) L

19.0

QC21

FINAL INSPECTION/W/O RELEASE



(10)

Comment: FINAL INSPECTION/W/O RELEASE

7/03/06

Job Completion



U 87-03-06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

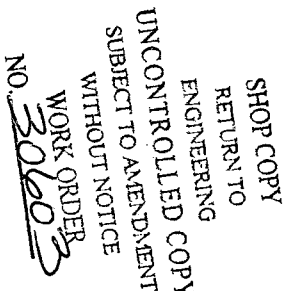
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries

06.03.21 UP
06.03.21

PART



- 1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9) ϕ 1.000 O.D.
(REF DART SPEC. M7075T73R1.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER
END OF THE BAR

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	REV. B
DATE	06.01.10		TITLE	D3197	SHEET 1 OF 1
A	03.07.01		BAR	SCALE 1:1	
B	06.01.10		CHG PIP PIN; ADD D3242-1 TAG		

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